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Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No. CNC/QA/FM/02

Rev. No. 01

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		9823-R1	
2	Machined By		U7L MIC sharp	30/50/66
3	Pallet Die No.		10582 (6.0)mm	Day 10 - 609 Rev 01
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 mm OD SHP - 693mm	3rd height 31mm
6	Inside Diameter	Drg. No.	548.1 mm	
7	Width of Pellet Die	Drg. No.	195 mm	
8	Grooves as per Drawing	Drg. No.	32x7x8mm center groove	4x8 deep
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	(face ground)
11	Tapping Operator		MIC Sharp	45x2 mm
12	Tapping PCD		619 mm	
13	Tapping Hole Diameter		M16 Check M16 Bell	Tapper
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drilling Dip - 33.8mm Tapping Depth - 31.5mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Janju 14/8/23

Tapping Mark
Holes - 4 Both
side

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	OK
4	Defective Holes (If Any)		N/A

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK (30°)	φ 6.5mm	φ 7.0		
2	External Relief Dia	φ 6.5, φ 7.0	36mm All Raw	16mm All Raw		
3	External Relief Depth					
4	Inspection Done Before Hardening By (Name)		Sanju			
5	Material Sent For Hardening By (Name)		hark	permes		
6	Material Sent For Hardening On Date		14	8	23	

Inspected By (Sign) & Date

Janju 14/8/23

Signature
14/8/23

Reviewed by (Engineer-CNC)

Manager-QA